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TITLE: MOLD FOR CONTINUOUS CASTING

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## ABSTRACT:

PURPOSE: To extend the life of a casting mold by forming the mold into the construction wherein the cooling power of a short side copper plate using cooling water is changed in accordance with the change in the thermal load in a vertical direction in a casting billet.

CONSTITUTION: A casting mold is made into the construction wherein the cooling power of a short side copper plate 2 using cooling water is changed in accordance with the change in the thermal load in a vertical direction in a casting billet. More specifically, (1), the passage speed of cooling water is changed by adjusting the depth and length of a slit 3 in each passage for cooling water. (2), the thickness over the entire part of the plate 2 is changed in a vertical direction. (3), the width of the slit 3 is made narrow toward the upper direction. (4), the thickness of a coating 6 having the thermal conductivity lower than the thermal conductivity of the copper base material is changed in a vertical direction. The cooling power of the short side copper plate with respect to thermal load is adjusted by the various combinations thereof and the temp. over the entire part of the short side copper plate is maintained uniformly.

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